

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GASKET		
Job Number	: 35543				
Estimate Number	: 13062				
P.O. Number	: <i>N/A</i>	Part Number	: D324511		
This Issue	: 11/6/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3245 REV B		
Prsht Rev.	: NC	Project Number	: N/A		
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B		
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>		
Written By	: <u><i>[Signature]</i></u>	Due Date	: 11/12/2007	Qty:	8 Um: Each:
Checked & Approved By	: <u><i>[Signature]</i></u>				
Comment	: Est B 04.12.06 Made in-house KJ/JLM				
	Est Rev:C ecn 1052/water jet 07-11-05 DD verified by:EC				

Job Number:

1.0	D3245	Gasket
-----	-------	--------

Comment: Qty.: 0.0460 sf(s)/Unit Total : 0.3679 sf(s)

GASKET

Batch: B31158 1B07-11-8

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

Comment: FLOW WATER JET

1-Cut as per Dwg D3245 18 17-11-8

Dwg Rev: 5

Prog Rev: B

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 183

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 04/11/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/6/2007 1:13:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 35543

Part Number: D324511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



⑧

Comment: FINAL INSPECTION/W/O RELEASE

D 07.11.12

Job Completion



u 07.11.12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-041 ACCESS PANEL ASSEMBLY

D3245-042 ACCESS PANEL ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

B	REMOVE Ø0.204 HOLES FROM D3245-1-1F. REMOVE MS21060-L3K NUTPLATES & DURABLA BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3245 TITLE ACCESS PANEL ASSEMBLY <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	SCALE 1:2.5 REV. B SHEET 1 OF 7	
DATE	07.10.02		

RELEASED
147 07-10-23

NOTES:

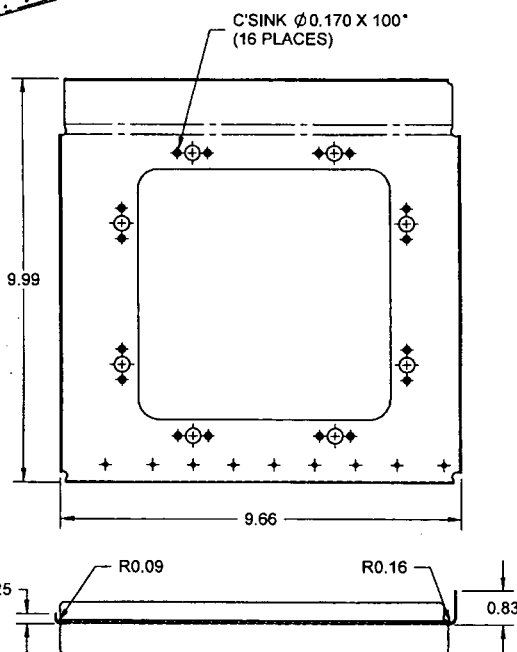
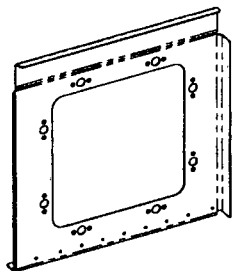
- (1) MATERIAL: N/A
- (2) FINISH: NONE
- (3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- (4) UNITS: INCHES UNLESS OTHERWISE NOTED
- (5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- (6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- (7) WEIGHT: 0.83 lbs

RETURN TO
ENGINEERING

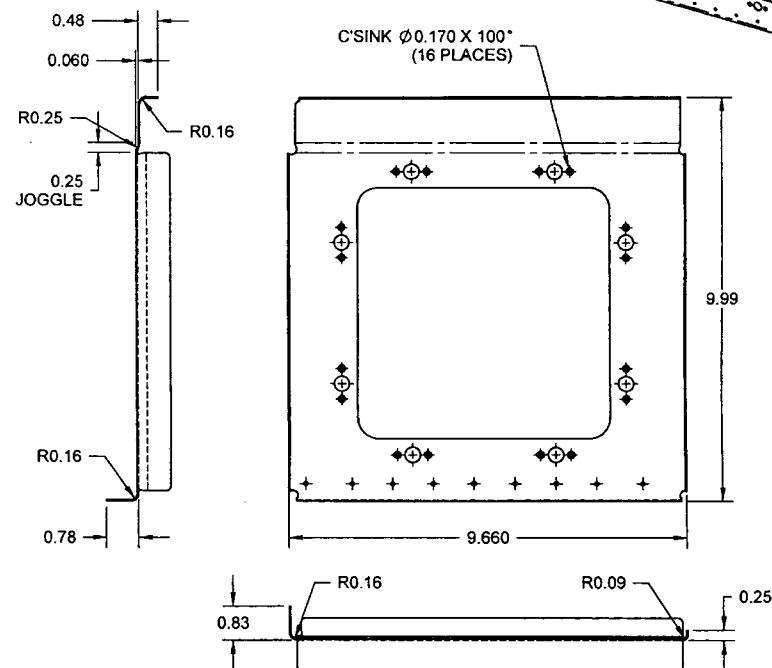
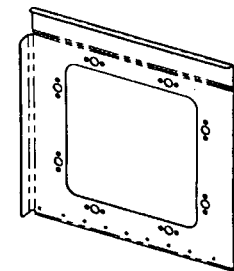
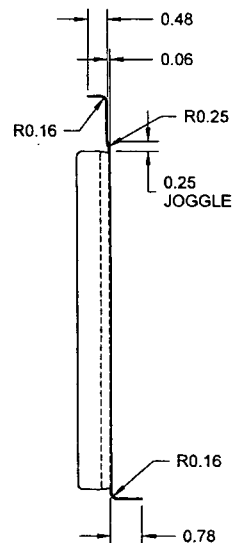
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

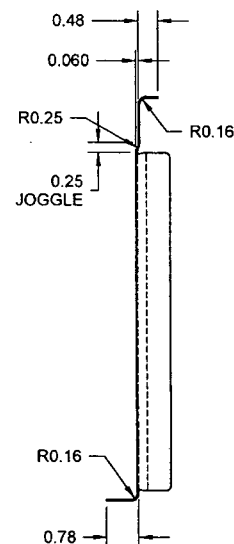
No. 35543



D3245-1 PANEL BEND DETAIL, LH



D3245-2 PANEL BEND DETAIL, RH



RELEASED
10-27-23

- NOTES:
- 1) MATERIAL: MAKE FROM D3245-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.70 lbs

DESIGN	<i>TH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO. D3245	REV. B
MFG. APPR.	<i>IS</i>	SHEET 2 OF 7	
APPROVED	<i>TH</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	ACCESS PANEL ASSEMBLY	1:3
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

355243

8 7 6 5 4 3 2 1

D3245-5 DOOR
2351-20-009-C3Y STUD (1)
127H-35 GROMMET (1)
(8 PLACES)

D3245-7 GASKET (REF)
8.00
(TYP, REF)

D3245-043 DOOR ASSEMBLY

INSTALL D3245-7
GASKET ON THIS SIDE

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

NOTES:

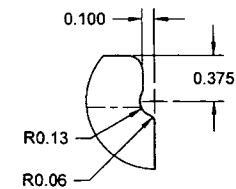
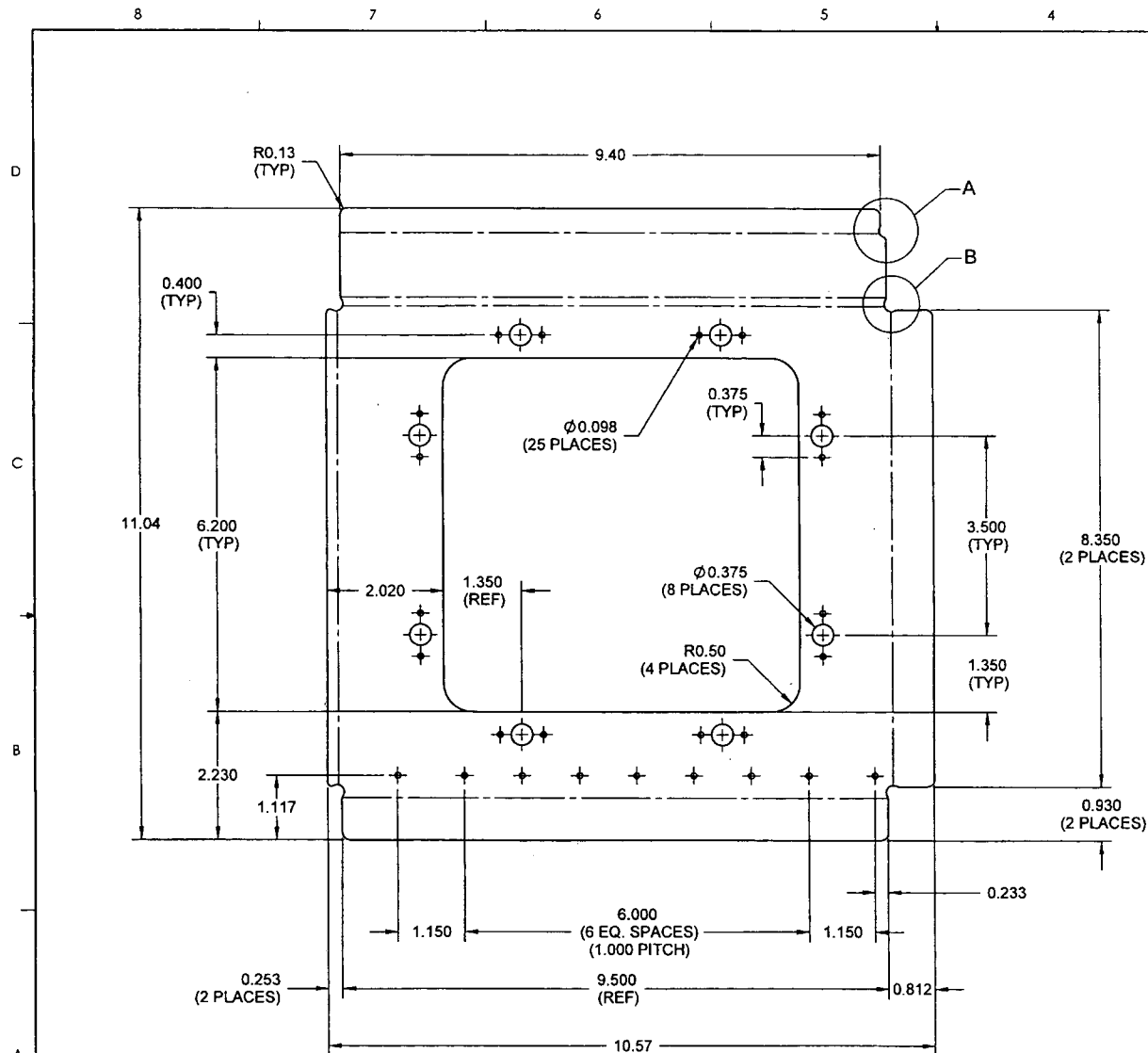
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

DESIGN	TH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3245	SHEET 3 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY	1:2
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

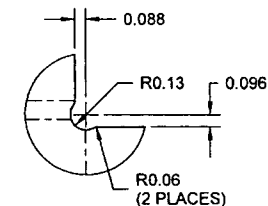
RELEASED
7-27-03

WORK ORDER
3543
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

7 6 5 4 3 2 1



DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
(TYP. 4 PLACES)
SCALE 1:1

NOTES:

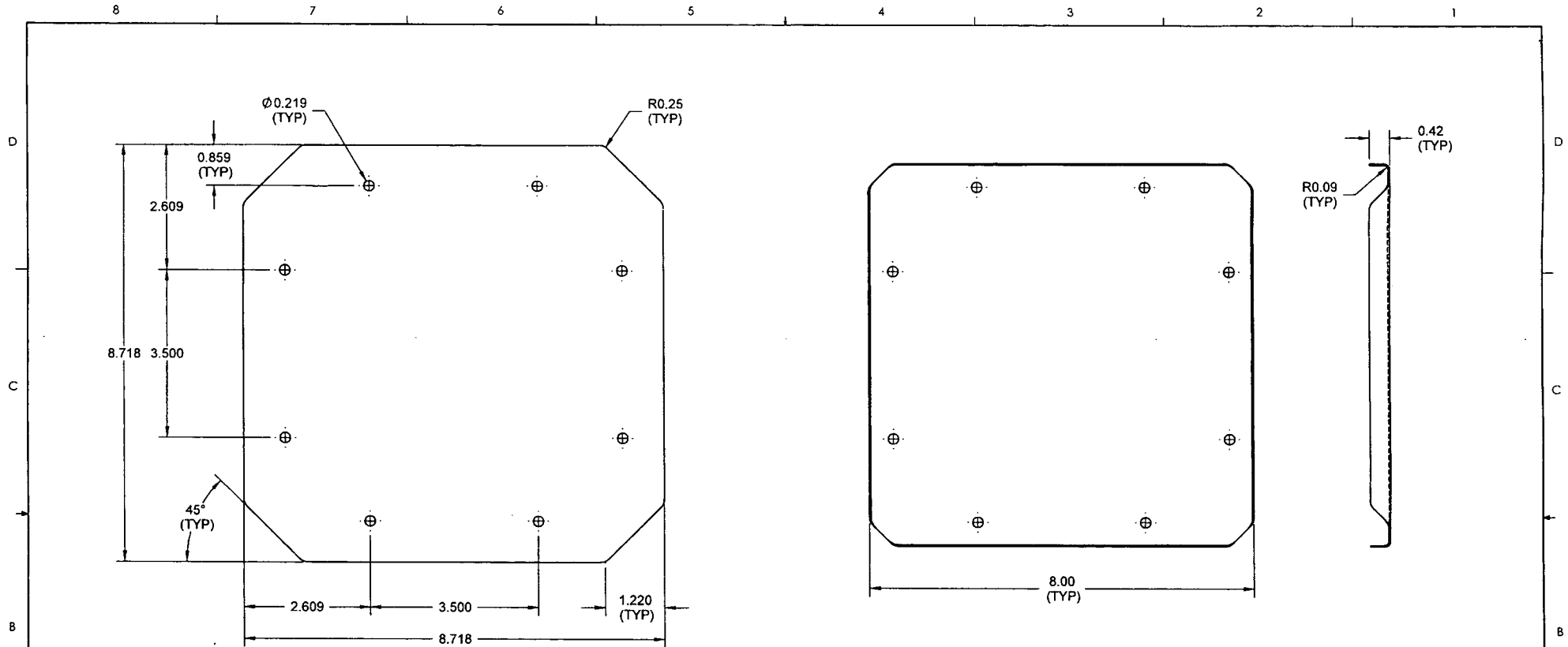
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
(0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	#	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3245	SHEET 4 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY	1:2
DATE	07.10.02	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
WORK ORDER
35543
SUBJECT TO AMENDMENT
WITHOUT NOTICE

D3245-1F PANEL FLAT PATTERN



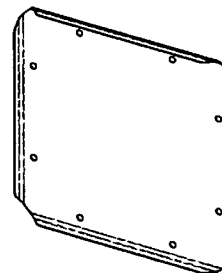
D3245-3F DOOR FLAT PATTERN

D3245-3 DOOR BENDING DETAIL

RELEASED
07.10.02

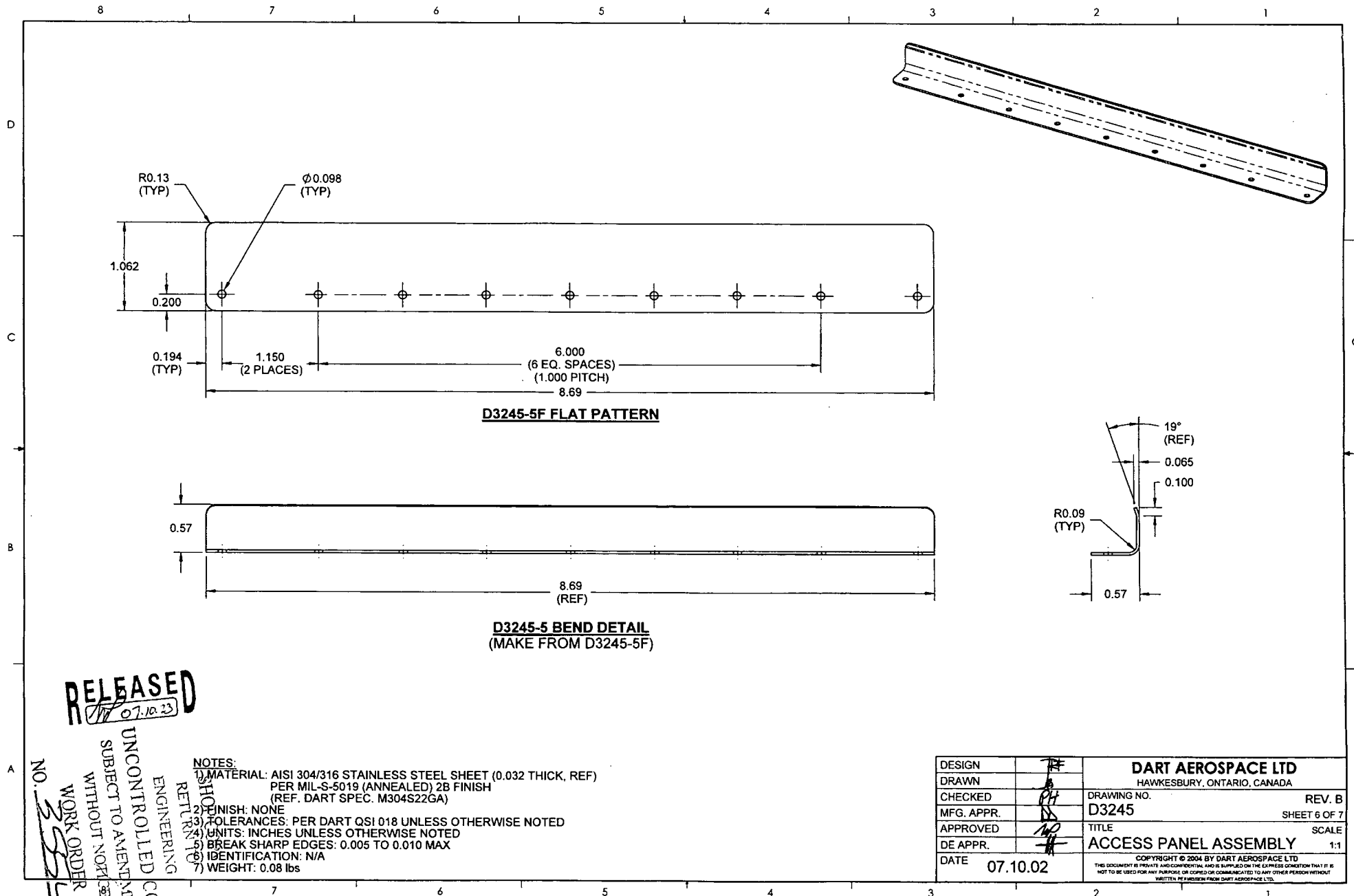
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs



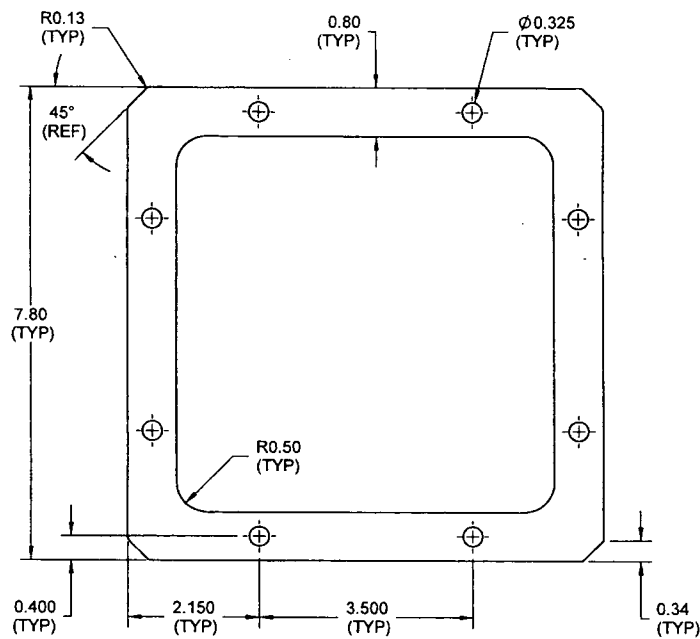
DESIGN	7F	DART AEROSPACE LTD	
DRAWN	7F	HAWKESBURY, ONTARIO, CANADA	
CHECKED	7F	DRAWING NO.	REV. B
MFG. APPR.	7F	D3245	SHEET 5 OF 7
APPROVED	7F	TITLE	SCALE
DE APPR.	7F	ACCESS PANEL ASSEMBLY	1:2
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

NO. 35543
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

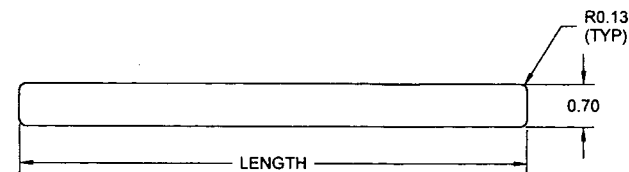


RELEASED
07.10.23

NO. 3543
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
DART AEROSPACE LTD



D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

RELEASED
(W 07.10.02)

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO.	REV. B
CHECKED	PH	D3245	SHEET 7 OF 7
MFG. APPR.	PH	TITLE	SCALE
APPROVED	PH	ACCESS PANEL ASSEMBLY	1:2
DE APPR.	PH	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.10.02		

NO. 355473
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

